

Date: Monday, 5/1/2006 4:22:48 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING ANGLE
Job Number	: 26908		
Estimate Number	: 10415		
P.O. Number	: NIA	Part Number	: D2417
This Issue	: 5/1/2006	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D2417 REV. B
First Issue	: NIA	Project Number	: N/A
Previous Run	: NIA	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: NIA
Written By	: <u>See comment below</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>06.05.02</u>	Qty:	2 Um: Each
Comment	: Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.0411 sf(s)/Unit Total : 0.0821 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
(M2024T3S.063) Batch: M19059  
Identify for D2417

SAD 06.05.24 (2)

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut blank: 3.300" x 1.550" Grain along 1.550"

N/A 06.05.18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA328 and Dwg D2417  
Stack of 7  
Identify as D2417

Water Jet

Dwg B  
Prog B

SAD 06.05.24

(2)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06.05.24 (2)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK


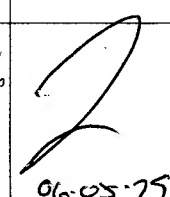
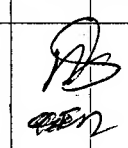
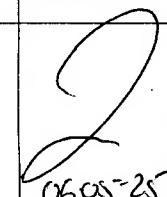
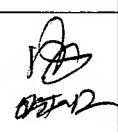
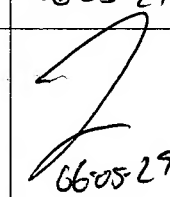
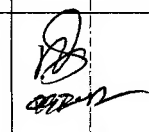
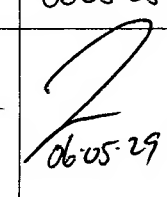
SP 06.05.24 Y2

P10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-25	4	grain in wrong direction. <del>Ensure</del> 2 parts scrap.		Ensure employee checks the grain direction on the Dwg. Scrap: destroy and replace parts.	SAD 06/05/26	 06-05-25		 06-05-25
06-05-29	3	.128 holes ovalized a little by .009, from water jet cutting over the cross ribs.		holes are acceptable and will assemble well.	N/A	 06-05-29		 06-05-29

NOTE: Date & initial all entries

Date:  
User:

Monday, 5/1/2006 4:22:49 PM  
Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 26908

Part Number: D2417

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

En 06/05/29

✓

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

SB 06/06/01

(2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Open D2417 mounting angle hole to Ø0.437" as per Dwg D2417.

2- Deburr hole

N/A 06/06/01

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/02

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 06/06/02

(2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

06/06/05

(2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STY

06/06/05

(2)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/06

(2)

Job Completion



u 06/06/06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

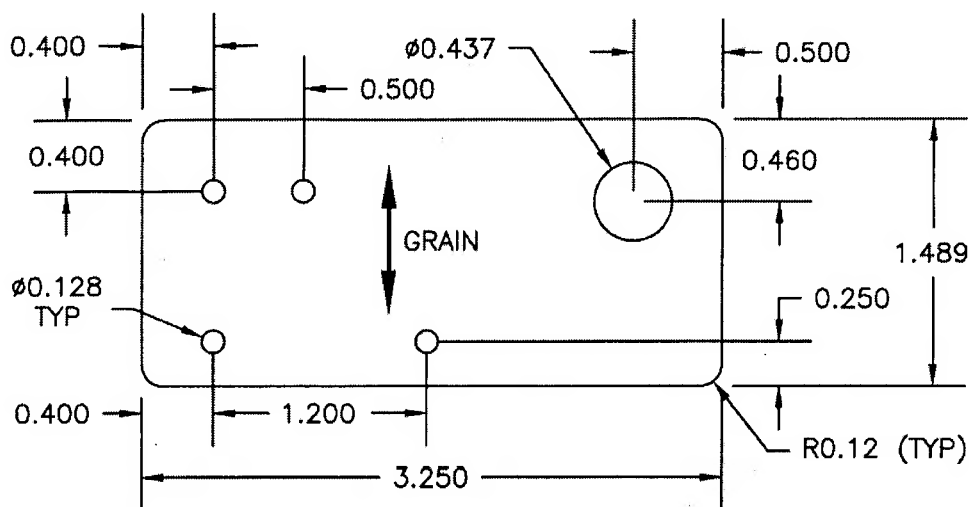
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

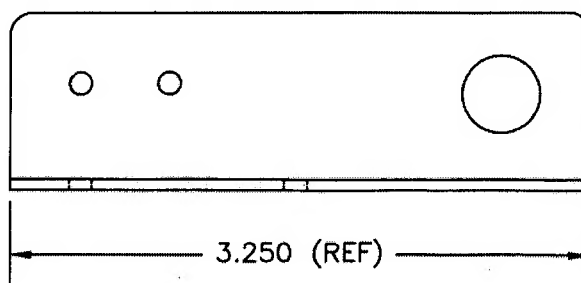
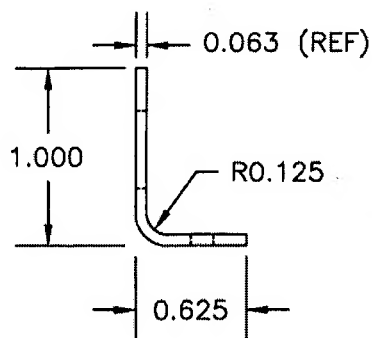


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2417	REV. B SHEET 1 OF 1
DATE 03.04.09		TITLE MOUNTING ANGLE	SCALE 1:1
A	95.04.06	NEW ISSUE	
B	03.04.09	ADDED $\phi 0.128$ & FLAT PATTERN	

RELEASED  
03.05.07



**FLAT PATTERN**



**BEND DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC 2024-T3S.063)
- 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
- 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26908

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DART AEROSPACE LTD		Work Order: 26908
Description: MTG ANGLE		Part Number: D2417
Inspection Dwg: 2417 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.250	$\pm 0.010$	3.256	✓		Vern	
1.200	$\pm 0.010$	1.194	✓		Vern	
1.489	$\pm 0.010$	1.491	✓		Vern	
0.250	$\pm 0.010$	0.251	✓		Vern	
0.460	$\pm 0.010$	0.460	✓		Vern	
0.500	$\pm 0.010$	0.502	✓		Vern	
0.500	$\pm 0.010$	0.502	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
0.400	$\pm 0.010$	0.397	✓		Vern	
Ø 0.128	$+0.005 / -0.001$	Ø 0.128	✓		Vern	
R0.12	$\pm 0.016$	R0.12	✓		Radius gauge	
Ø 0.437	$+0.006 / -0.001$	Ø 0.438	✓		Vern	

Measured by: SAD/13	Audited by: En	Prototype Approval:
Date: 06/05/24	Date: 06/05/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

*[Signature]*